

Work Order ID 155469

Tuesday, January 17, 2017 11:20:02 AM

155469

Page 1

Item ID: D3298-007 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Tube Assembly
Start Date: 1/12/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 1/17/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: DAS 21 Date: JAN 17 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3298	B								
100		0.00							
100	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Bend tube as per template D3298-007T1 & Dwg D3298Flare end as per Dwg D3298. Ensure that sleeves and coupling are installed first								
110		0.00							
110	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
120		0.00							
120	Identify as per dwg & Stock Location: <u>St210</u>								
Packaging	Memo	0.00							
Packaging									

DAS
19
9-89DAS
38
9-89
JAN 24 2017DAS
6
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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130	QC21- Final Inspection - Work Order Release	0.00							
130							DAS 21	JAN 25 2017	
QC	Memo	0.00					9-88		
Quality Control									

ME
17-1-24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Picklist Print

Tuesday, January 17, 2017 11:20:01 AM

Page 1

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155469

Parent Item: D3298-007

D3298-007

Parent Item Name: Tube Assembly

Start Date: 1/12/2017

Required Date: 1/17/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A04.09.02New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN818-6D		Purchased	No			100	Each	34.0000	2	8			
AN818-6D									**				
Nut													

Location

Loc Qty

Loc Code

ST325

34

M136263

16

M136295

18

M6061T6T0.375W.035

Purchased

No

100

f

52.1800

0.6666

2.806737

M6061T6T0.375W.035

6061-T6 RD Tube .375 x.035W

Location

Loc Qty

Loc Code

MAT013

52.179985

124491

52.12

m130071

0.059985

MS20819-6D

Purchased

No

100

Each

15.0000

2

8

MS20819-6D

Sleeve

Location

Loc Qty

Loc Code

ST306

15

m135683

15

DQA: _____ Date: _____

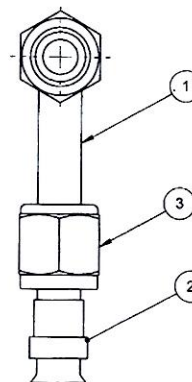
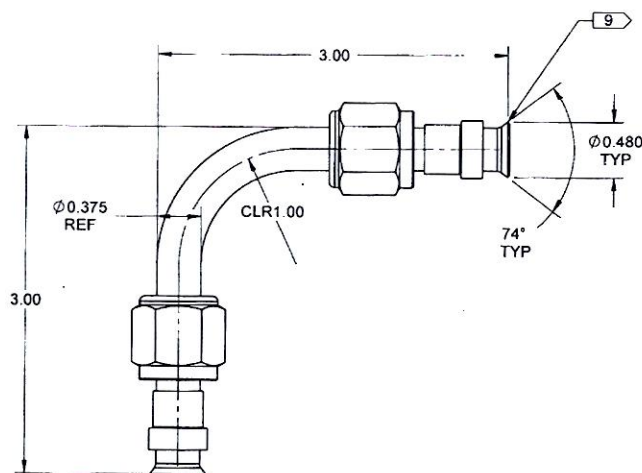
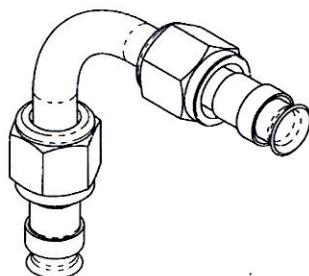


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OTHER : _____																					



ITEM	QTY -007	P/N	DESCRIPTION
1	X	D3298-007	TUBE ASSEMBLY
2	2	MS20819-8D	SLEEVE
3	2	AN818-6D	NUT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 155469
1701-25

D3298-007 TUBE ASSEMBLY

RELEASED
2010-01-16

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.375 O.D. x 0.035 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.375W.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3298-007" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.05 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D3298-007T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS, TYPICAL
- 10) ENSURE SEAMLESS TUBING IS USED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3298	SHEET 4 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	TUBE ASSEMBLIES	NTS
DATE	09.12.30	COPYRIGHT © 2004 BY DART AEROSPACE LTD	